Dart Aerospace Ltd.

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 48383		
Estimate Number	: 11712		
P.O. Number	:	Part Number	: D27552
This Issue	: 08/06/2009 S.O. No. :	Drawing Number	: D2755 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 19/06/2009 Qty: 10 Um: Each
Checked & Approved By	: _JD 09·06·08_		
Comment	: Est:B 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D2762108	Extrusion

Comment: Qty.:   0.2712 Each(s)/Unit   Total :   2.7122 Each(s)
Extrusion
Batch: _B7479_   _09/06/10_   (10)

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut D2762 extrusion to 3.100" +0.015"/-0.000   _09/06/10_   (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio H2755-2 and drawing D2755
Deburr   _JL 09/06/10_

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE   _JL 09/06/10_

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK   _09/06/10_

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** LUG

Job Number: 48383 | **Part Number:** D27552

Job Number:

Seq. #:	Machine Or Operation:	Description :		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		(10)

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

BK 09-03-10

7.0	POWDER COATING	POWDER COATING

M 111 472

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *11:15am*
OVEN TEMPERATURE: *320°F*
FINISH TIME: *11:45am*   *JB 09-06-11*   *(10)*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION		(10)

Comment: INSPECT POWDER COAT   *BK 09-06-11*

9.0	PACKAGING 1	PACKAGING RESOURCE #1		(10x)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *479*   *9/6/11*   *JB*

10.0	QC21	FINAL INSPECTION/W/O RELEASE

09/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

MF 09-06-12

DART AEROSPACE LTD	Work Order: 48383
Description: aft bracket	Part Number: D2755-2
Inspection Dwg: D2755 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	± .010	3.003	✓			
2.000	± .010	2.000	✓			
.187	± .010	.181	✓			
⌀.500	± .010	.500	✓			
.250	± .010	.246	✓			
⌀.625	± .010	.625	✓			
.50	± .030	.498	✓			
2.451	± .010	.				
.500	± .010	.501	✓			
1.500	± .010	1.495	✓			
⌀.257	+.005 -.001	.259	✓			
⌀.500	± .010	.500	✓			
3.000	± .010	3.000	✓			
2.000	± .010	1.999	✓			
.500	± .010	.500	✓			

Measured by: J.L	Audited by:	Prototype Approval:	N/A
Date: 09/06/10	Date: 09/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2755	REV. B SHEET 1 OF 1
DATE 98.04.29		TITLE AFT BRACKET	SCALE 1:1
A	98.04.01	NEW ISSUE	
B	98.04.29	ADDED −1 AND −2 IDENTIFICATION	

R0.063 (TYP)

3.000
2.000
0.50

0.187

R0.500

R0.625

NOTE: THIS
SURFACE
CONTOURED
TO FIT
AIRCRAFT
FUSELAGE

MATERIAL: MAKE FROM EXTRUSION D2762
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
        POWDER COAT WHITE PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.250

2.451
0.500
1.088

R0.500
(TYP)

∅0.257 (TYP)

1.500

3.000

2.000

R0.500

∅0.257

0.50

R0.250 (TYP)
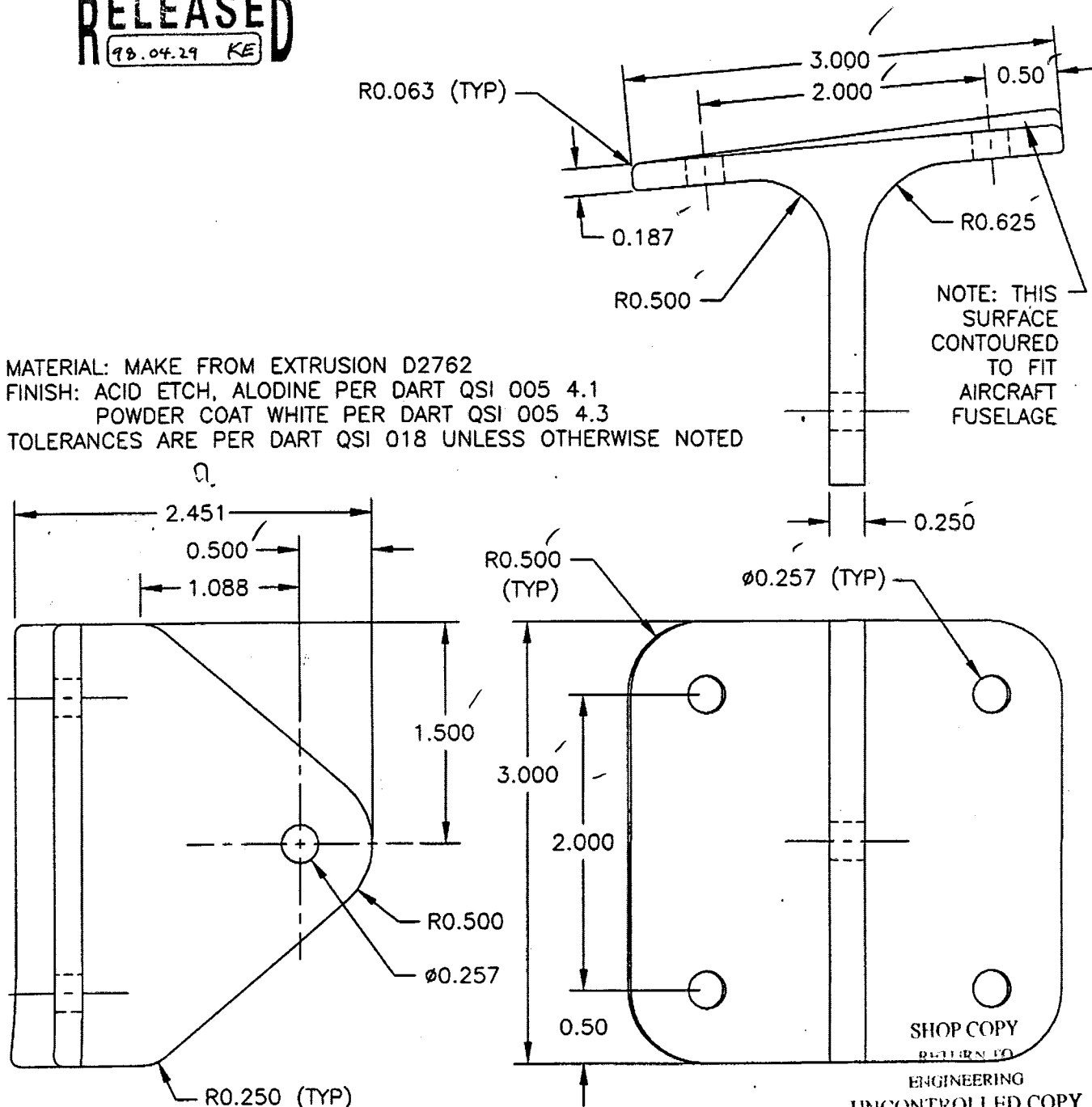
D2755−1 LH AFT BRACKET (SHOWN)
D2755−2 RH AFT BRACKET (OPPOSITE)

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